



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18543-3
Job Sheet 192365



Part No: RBT18543-3

Job Qty: 1 pcs

Part Name: Stiffener Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/19

Job Tracking No:

Due Date: 3/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18543 Rev.G IPP Rev. A 19.03.05 New issue DP Verify DD/IPP Rev. B 19.04.01 drawing revision
DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S169625



Part: RBT18543-3

Job No: 192365

Serial No/Batch: S169625

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 04/04/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	3/26/19	0.00	0.20		Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	3/26/19	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	3/26/19	0.00	0.00		Packaging 3 - 1 - B4B		DAS 40 9-89 APR 04 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	1 pcs	3/26/19	0.00	0.00		QC 21 - SA - 21		DAS 21 9-89 APR 04 2019
							QC 21 - SA - 70		

Part Op
Descriptions: 100 - Assemble as per DWG. See note 8.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
93286A013	Aluminum Washer 0.265" ID. X 0.688" OD.	8 Ea (8 ea)	100-Small Fab - 1	3161546
97447A651	Aluminum Blind Rivets 1/4" Dia. X 1/2" Long	8 Ea (8 ea)	100-Small Fab - 1	3161544
DTSP10002	Handle	2 pcs (2 ea)	100-Small Fab - 1	3163648
RBT18543-4	Stiffener	1 pcs (1 ea)	100-Small Fab - 1	3167845

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	93286A013	8	168	0
	97447A651	8	165	0
	DTSP10002	2	8	0
	RBT18543-4	1	1	0

Part Specifications

Specifications could not be found.

Plex 4/4/19 10:22 AM dart.leclair.mathieu

Entered: _____ Date: _____



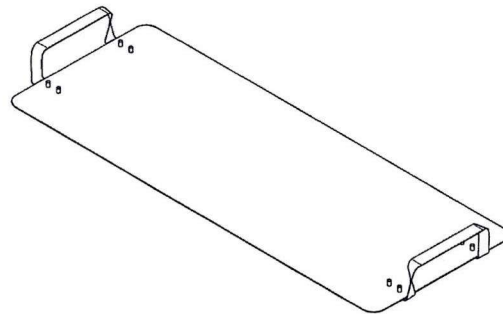
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

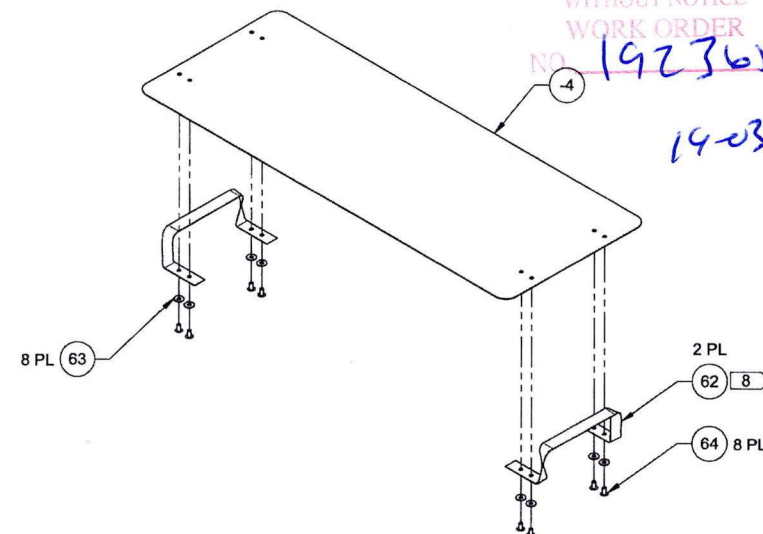
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

ITEM #	QTY	PART #	PART TITLE
-4	1	RBT18543-4	STIFFENER
62	2	DTSP10002	HANDLE
63	8	McMaster#93286A013 OR EQUIV.	ALUMINUM WASHER 0.265" ID. X 0.688" OD. X 0.030"-0.055" THK.
64	8	McMaster#97447A651 OR EQUIV.	ALUMINUM BLIND RIVETS 1/4" DIA. X 1/2" LG.



RBT18543-3 STIFFENER ASSEMBLY



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEMS 62 ONTO ITEM -4 USING ITEMS 64

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 192365 MWS
19-03-21

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	DP	RBT18543	SHEET 6 OF 10
APPROVED	Wf	TITLE	SCALE
		LONG RANGER FIELD MAINTENANCE KIT	NTS
DATE	3/6/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			